

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021857**Date Inspected:** 19-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang and Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) at Trial Assembly Areas

Segment 12BW (Cantilever Bracket)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) weld. The weld joint was designated as OBE12C-018. The welder identification was 046709 and was observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-B-P-2212-Tc-U4b-FCM-1. The piece mark was identified as Cantilever Brackets welded at Edge Panel at PP 114.5, Cross Beam side.

Please reference the pictures attached for more comprehensive details.

Segment 12CW (Cantilever Bracket)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) weld. The weld joint was designated as OBE12C-026. The welder identification

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was 041713 and was observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-B-P-2212-Tc-U4b-FCM-1. The piece mark was identified as Cantilever Brackets welded at Edge Panel at PP 116.5, Cross Beam side.

Please reference the pictures attached for more comprehensive details.

Segment 12BW (Cantilever Bracket)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) weld. The weld joint was designated as OBE12C-014. The welder identification was 046709 and was observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-B-P-2212-Tc-U4b-FCM-1. The piece mark was identified as Cantilever Brackets welded at Edge Panel at PP 113.5, Cross Beam side.

Segment 12CW (Floor Beam to Stiffener weld)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Fillet weld. The weld joint was designated as CA3010E-286. The welder identification was 057333 and observed welding in the 4F (Overhead) position using approved Welding Procedure Specification WPS-B-P-2114-FCM-1. The piece mark was identified as weld connecting the Floor Beam to the Stiffeners, Counter Weight side.

Please reference the pictures attached for more comprehensive details.

Segment 12BE (Cantilever Bracket)

This QA Inspector observed the in-process welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) weld. The weld joint was designated as OBE12C-021. The welder identification was 044504 and was observed welding in the 4G (Overhead) position using approved Welding Procedure Specification WPS-B-P-2214-Tc-U4b-FCM-1. The piece mark was identified as Cantilever Brackets welded at Edge Panel at PP 114.5, Cross Beam side.

Please reference the pictures attached for more comprehensive details.

Segment 12BE (Full Height Diaphragm)

This QA Inspector observed the repair welding by Shielded Metal Arc Welding (SMAW) process on a Complete Joint Penetration (CJP) groove weld. The Weld joint was designated as Seg3002M-090. The welder identification was 044504 and was observed welding in the 2G (Horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G(2F)-Repair-FCM-1. The piece mark was identified as full height Longitudinal Diaphragm web to Bottom Panel hold back weld at work point E3.

Please reference the pictures attached for more comprehensive details.

Cross Beam # 17 to Segment 12AW

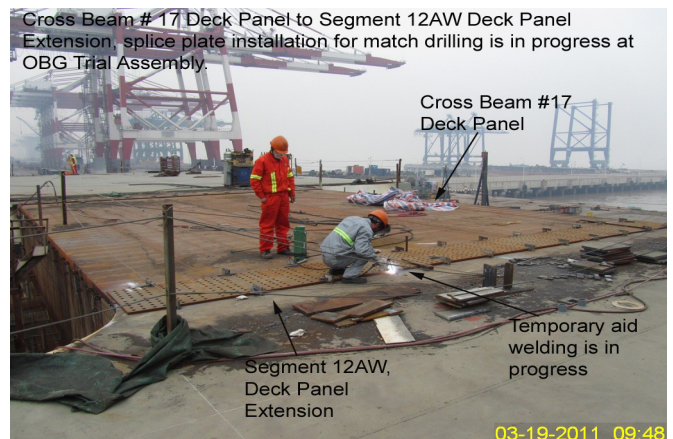
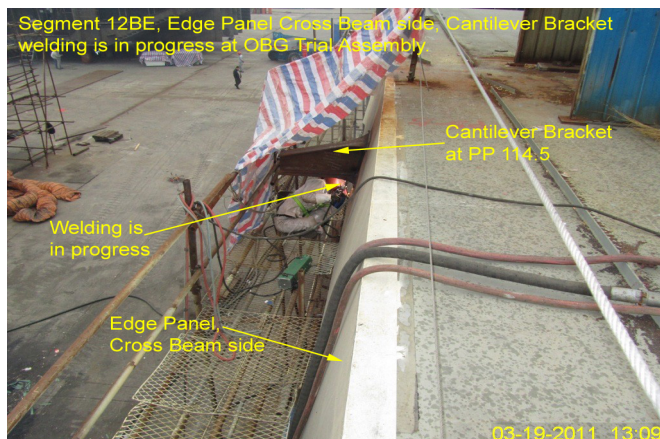
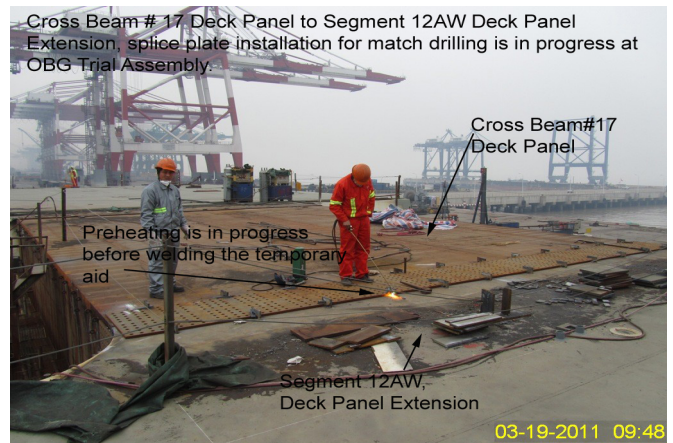
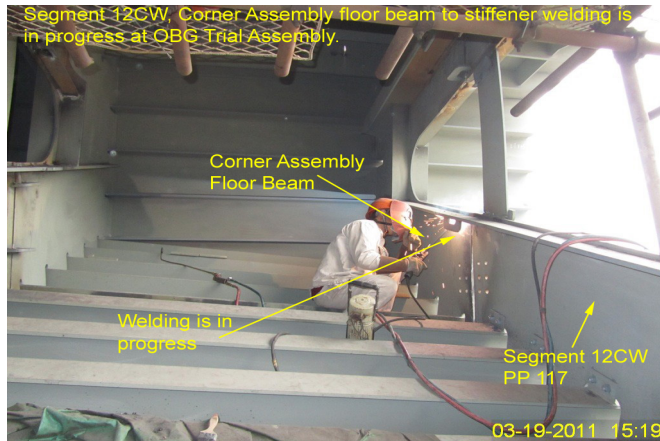
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This QA Inspector observed ZPMC personnel installing the splice plate between the Cross Beam # 17 to Segment 12AW Deck Panel Extension between PP 110, PP 111 and PP 112 for match drilling.

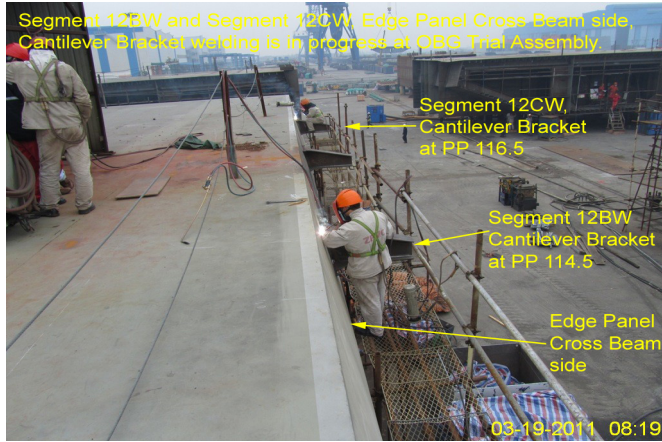
Please reference the pictures attached for more comprehensive details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
